

MANDATORY QUALITY ASSURANCE PROVISIONS

P/N: (78286) 65130-07306-101

NOMEN: STACK BEARING NUT

NSN: 5310-01-129-3376

CRITICALITY DETERMINATION: Critical Safety Item

Determination Date: June 23, 2004

APPLICABLE CLAUSES:

Articles to be furnished hereunder shall be manufactured, tested and inspected in accordance with drawing number (78286) 65130-07306, Revision "C" or latest revision and all details and specifications referenced therein.

I. Process/Operation Sheets Revision "C" or latest revision date shall be utilized in manufacture of the articles to be furnished hereunder.

II. Quality/Inspection Requirements

- A. MIL-I-45208 applies or ISO 9000 equivalent.
- B. First Article testing applies. (Government Testing)
- C. Production Lot Testing applies. (Government Testing)
- D. Mandatory Inspection required.

III. Supplemental Requirements

- A. Additionally, paragraphs 3.1-3.5, 5.1-5.2, and 6.1-6.2 of MIL-Q-9858 apply or ISO 9000 equivalent applies.

B. The contractor shall identify on the process/operation sheets, a tracking method that is traceable to the contract, all manufacturing sources performing processes/operations outside of their facilities. These sheets shall not be revised or altered after the successful completion of First Article or Production Lot Testing without approval from the ESA located at the Naval Air Depot, Cherry Point, North Carolina, via the PCO.

C. The Inspection Method Sheets, which list the characteristics of each item produced under the contract shall have serial number traceability to the raw material, casting, or forging. The tracking method used on the inspection/method sheets shall be traceable to the contract. In addition, the contractor is responsible for providing completed inspection method sheets showing the actual dimensions taken of all critical characteristics.

MANDATORY QUALITY ASSURANCE PROVISIONS continued

D. The contractor shall provide all certificates of compliance for any material purchased or any processes performed by a sub-vendor, i.e. heat treat, NDI, plating, painting, etc. All material and/or process sub-vendors shall be OEM approved sources.

E. Markings should be I/A/W MIL-STD-130 latest revision, paragraphs 5.3.3(a), (b), (c) and (g). Method and location shall be I/A/W drawing.

IV. Mandatory Inspection Requirements

During production, mandatory inspection is required to be accomplished by the contractor as follows:

A. Level of Inspection (LOI).

- 1) Critical Characteristics: 100% inspection shall apply
- 2) Major and Minor Characteristics - LOI shall be I/A/W sampling plan acceptable to the QAR

B. Critical Characteristics Sikorsky Drawing (78286) 65130-07306:

- 1) Note 3 – Heat treat to 180,000 PSI minimum UTS Rockwell C39-43 per MIL-H-6875.
- 2) Note 5 – Inspection of 4.500-12UNJS-3B threads per gaging method c of MIL-S-8879 or MIL-S-7742.
- 3) Note 6-Magnetic Particle inspection per SS8805.
- 4) Note 8- Serialize per SS9070 using item identification prefix 418
- 5) Material Analysis: 4340 STL per AMS 6414.

C. Major and Minor Characteristics

- 1) Shall be defined by the contractor subject to QAR concurrence, unless defined on applicable drawings and associated specifications.

FIRST ARTICLE TEST REQUIREMENTS (GOVERNMENT TESTING)

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I. First Article Inspection/Test Criteria:

The tests to be performed under the First Article approval clause of the contract are:

A. Compliance with (78286) 65130-07306, Revision "C" or latest revision and all specifications referenced therein.

B. Identification: Verification and certification that the parts are serialized and identified per the requirements of (78286) 65130-07306, Revision "C" or latest revision and all specifications referenced therein.

C. Packaging and Preservation: Verification that the parts have been packaged and preserved per the requirements of the contract.

D. Verification and certification of the overall workmanship of the First Article Sample(s).

E. Dimensional: 100% dimensional.

F. Non-Destructive Inspection: Verification and certification of Magnetic Particle Inspection per SS8805.

G. Fit/Form: Waived by engineering.

H. Verification of threads per gaging method c per MIL-S-8879 or MIL-S-7742.

I. Material Analysis of the First Article Sample(s):

1) Destructive material analysis to verify material composition of 4340 HDN Steel Per AMS 6414.

2) Verification of compliance with heat treatment to 180,000 PSI MIN. UTS C39-43 per MIL-H-6875.

J. Review of documentation as provided under DD 1423 requirements.

FIRST ARTICLE TESTS REQUIREMENTS (GOVERNMENT TESTING) continued

In addition to the above tests, the First Article(s) to be delivered hereunder shall also be subjected to those tests, which will demonstrate that the articles comply with contract requirements. The contractor shall be responsible for providing necessary parts and repair of the First Article(s) during testing.

II. Samples to be submitted for testing:

- A. Quantity 2 each.
- B. Estimated Cost: T.B.D.

III. Special Instructions:

A. Upon successful first article inspection all processes are to be frozen. Any changes to the manufacturing process will be cause for a new First Article Inspection.

B. One sample will be destroyed during testing and will not be returned to the contractor. One sample may be considered as production items under the contract provided the sample could be refurbished to ready for issue (RFI) condition and provided the sample has inspection approval of the cognizant QAR. Sample(s) may be shipped as production items only after all other units required under the contract have been produced and are ready for shipment.

C. Waiver of the destruction of the First Article test piece may be granted if the contractor provides a certified test coupon that is of the same material and has undergone the same special processes as the First Article test piece.

D. One sample is to be unpainted and all corrosive areas are to be coated with a light preservative on both samples.

Notification of Shipment of Material for Government Testing

A. Fourteen (14) days prior to shipment of the First Article Sample(s) the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO, ACO, and QAR. The contractor shall also arrange for preliminary inspection of test sample(s) by the CAO/QAR. The First Article Sample(s) shall be forwarded to the following First Article point of contact at the designated test facility:

**NAVAL AIR DEPOT
FIRST ARTICLE TEST-STA. 31B
ATTN: 3.3.2 (252) 464-7748
BLDG 154B CLEVELAND DR.
MCAS CHERRY POINT, NC 28533**

FIRST ARTICLE TESTS REQUIREMENTS (GOVERNMENT TESTING) continued

B. Upon shipment of First Article Sample(s), two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the PCO/ACO DSCR Code DSCP, and the designated test facility. In addition, the contractor must supply all detailed process/operation sheets, Inspection Method Sheets, First Article Test Report (Signed by the QAR), and all Certificates of Compliance for material (including chemical analysis), **Magnetic Particle Inspection** and any out-sourced process conducted on the First Article Sample(s). These forms and documentation may either be placed in the shipping container with the sample(s) or sent separately, however the envelopes shall be clearly marked, "DO NOT OPEN IN MAILROOM." These forms and documentation shall be sent to the following point of contact:

**NAVAL AIR DEPOT
FIRST ARTICLE TEST-STA. 31B
ATTN: 3.3.2 (252) 464-7748
BLDG 154B CLEVELAND DR.
MCAS CHERRY POINT, NC 28533**

Within 120 days after receipt of the sample(s) the test site shall complete testing/evaluation and submit a copy of their test report with conclusions and recommendations to DSCP.

PRODUCTION LOT TESTING REQUIREMENTS (GOVERNMENT TESTING)

P/N: (78286) 65130-07306-101

NOMEN: STACK BEARING NUT

NSN: 5310-01-129-3376

CRITICALITY DETERMINATION: Critical Safety Item

Determination Date: June 23, 2004

QUANTITY: 2

The material produced under contract shall be accepted by the cognizant CAO/QAR upon the successful completion of these requirements.

I. Production Lot Test Requirements

A. The cognizant CAO/QAR shall select the applicable number of items at random from the production lot per the ANSI/ASQC Z1-4 Sampling Procedures and Tables for Inspection by Attributes. In addition the QAR shall select the applicable number of items at random from each successive lot or portion thereof per the ANSI/ASQC Z1-4 Sampling Procedures and Tables for Inspection by Attributes.

B. Production Lot Testing to be completed during production after First Article Approval.

C. Sample(s) are to be unpainted. Corrosive areas to be coated with a light preservative.

D. If sample(s) are not destroyed during testing, they will be put into Defense Logistic Agency stock.

II. The tests to be performed under the Production Lot Sample testing provisions of the contract are:

A. Compliance with (78286) 65130-07306, Revision "C" or latest revision and all details and specifications referenced therein.

B. Identification: Verification and certification that the parts are serialized and identified per the requirements of (78286) 65130-07306, Revision "C" or latest revision and all details and specifications referenced therein.

C. Packaging and Preservation: Verification that the parts have been packaged and preserved per the requirements of the contract.

D. Visual: Verification and certification of the overall workmanship of the Production Lot Sample(s).

E. Dimensional: Verification and certification of 100% dimension check of finished Production Lot Sample(s).

F. Non-Destructive Inspection: Verification and certification of Magnetic Particle Inspection per SS8805.

PRODUCTION LOT TESTING REQUIREMENTS (GOVERNMENT TESTING)

G. Fit/Form/Function: Waived by engineering.

H. Material Analysis of the Production Lot Sample(s). NOTE: A destructive material analysis can be waived **ONLY** if a destructive material analysis was conducted by the Engineering Support Activity (ESA), AIR-4.3.4.1, Naval Air Depot, Cherry Point, NC during a successful First Article Inspection. However, all applicable material certificates of compliance will have to be provided for the production lot for verification of the material.

1) Destructive material analysis to verify material composition of 4340 HDN Steel Per AMS 6414.

2) Verification of compliance with heat treatment to 180,000 PSI MIN. UTS C39-43 per MIL-H-6875.

I. Review of documentation as provided under DD 1423 requirements.

In addition to the above tests, the Product Lot Sample(s) to be delivered hereunder shall also be subjected to those tests that will demonstrate that the sample(s) comply with contract requirements.

III. Testing Location

A. The contractor is to ship sample(s) and all required documentation and technical data to:

**NAVAL AIR DEPOT
FIRST ARTICLE TEST-STA. 31B
ATTN: 3.3.2 (252) 464-7748
BLDG 154B CLEVELAND DR.
MCAS CHERRY POINT, NC 28533**

B. The shipping container marking: "FOR PRODUCTION LOT TESTING. NON RFI MATERIAL. DO NOT TAKE UP IN STOCK. CONTRACT NUMBER _____."

Within fifteen (15) days of completion of Production Lot Testing the CAO/QAR shall prepare and submit two (2) copies of their test report with conclusions and recommendations to the Contracting Officer.

PRODUCTION LOT TESTING REQUIREMENTS (GOVERNMENT TESTING) continued

Shipment and Distribution of Sample(s):

A. Fourteen (14) days prior to shipment of Production Lot Sample(s) the contractor shall notify the designated test facility, in writing of the anticipated shipping date, with an information copy to the PCO, ACO and the QAR. The contractor shall also arrange for preliminary inspection of test samples by the CAO/QAR.

B. Upon shipment of the Production Lot Sample(s), two (2) copies of the Material Inspection and Receiving Report (DD Form 250), bearing the QAR's signature and indication of preliminary inspection, shall be forwarded to the PCO/ACO DSCP (Code DSCP), and the testing facility. In addition, the contractor shall provide all detailed Process/Operation Sheets, Inspection Method Sheets, First Article Test Report (Signed by the QAR), and all Certificates of Compliance for material (including chemical analysis), Magnetic Particle Inspection, any out-sourced process conducted on the Production Lot Sample(s) and all technical data used to manufacture the Production Lot Sample(s) to the testing facility. The envelopes shall be clearly marked, "DO NOT OPEN IN MAILROOM".

C. Production Lot Sample(s) may be considered as production items under the contract provided the sample(s) can be refurbished to Ready for Issue (RFI) condition and provided sample(s) have inspection approval from the cognizant DCMAO and the ESA engineer (H53ISST.2 (AIR-4.3.3)). Sample(s) may be shipped as production items ONLY after all other units required under contract have been produced and are ready for shipment.

D. Sample(s) will be returned to the contractor. The contractor must provide material disposition instructions to:

**NAVAL AIR DEPOT
FIRST ARTICLE TEST-STA. 31B
ATTN: 3.3.2 (252) 464-7748
BLDG 154B CLEVELAND DR.
MCAS CHERRY POINT, NC 28533**

E. The designated test facility and the contracting officer shall be notified as to all shipping data applicable to the sample(s), such as bill of lading number, method of shipment, etc. within fourteen (14) days prior to shipping.

PRODUCTION LOT TESTING APPROVAL (GOVERNMENT TESTING)

NSN: 5310-01-129-3376

P/N: (78286) 65130-07306-101

NOMENCLATURE: STACK BEARING NUT

CRITICALITY DETERMINATION: Critical Safety Item

Determination Date: June 23, 2004

A. The Production Lot Samples shall be:

1. Selected at random by the cognizant government QAR. Such samples shall be submitted via the cognizant government inspector, and all transportation charges prepaid by the contractor to:

**NAVAL AIR DEPOT
FIRST ARTICLE TEST-STA. 31B
ATTN: 3.3.2 (252) 464-7748
BLDG 154B CLEVELAND DR.
MCAS CHERRY POINT, NC 28533**

2. The samples shipping container and samples shall be identified by contract number, lot number and be clearly marked as follows:

**PRODUCTION LOT TEST SAMPLES
NON-RFI MATERIAL
DO NOT TAKE UP IN STOCK**

B. Such samples shall be delivered to the testing facility in sufficient time prior to the delivery date of the production articles to allow a 90 day period for testing and written notification by the contracting officer of the approval or disapproval of the samples. Within 120 days of the receipt of the samples, the testing facility shall notify the contracting officer, PCO/ACO of the results of the testing, together with the recommendation for approval or disapproval.

C. In the event the contractor does not receive written notification of approval or disapproval of the samples for a particular lot within 120 days from their submission for such testing, the contract delivery schedule shall be equitably adjusted as necessary.

D. If the contractor fails to deliver any Production Lot Samples for testing within the time or times specified, or if the contracting officer disapproves any Production Lot Samples, the contractor shall be deemed to have failed to make delivery within the meaning of the default clause of this contract, and this contract shall be subject to termination for default.

E. In order for a Production Lot to be acceptable, all samples representative of the lot must pass all the contract requirements. In the event a sample fails to pass such requirements, the lot will be rejected. In such event, the government may, at its option and at no additional cost to the government, (I) terminated all or any portion of this contract for default, (II) require the manufacture of a new Production Lot, or a rework of the rejected Production Lot if the means and procedures by the contractor for rework are acceptable to the government, or (III) require the

PRODUCTION LOT TESTING (GOVERNMENT TESTING) continued

submission of additional samples for test. The foregoing procedures shall apply to new or reworked Production Lots in the same way as they did to the original Production Lot.

F. For each additional sample or each resubmission of a modified sample which the contractor is required to submit for approval hereunder as a result of a failure of a previous sample to conform to the requirements of the specification, the contractor shall pay to the government the costs of reinspection, examination and retesting and the contractor and his sureties (if any) shall be liable for the amount of such costs.

G. The contractor must provide material disposition instructions to the First Article Coordinator at the **Naval Air Depot, Cherry Point, NC (Mr. Steve Lundberg, Code 3.3.2)** for the return of the production lot samples.

H. Nothing contained in the foregoing provisions of this clause, and not action of the government in accordance herewith, shall in any way prejudice the right of the government under this clause of this contract entitled default.

CONTRACT DATA REQUIREMENTS LIST

Form Approved
CMB No. 0704-0188

Public reporting burden for this collection of information is estimated to average 110 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. Please DO NOT RETURN your form to either of these addresses. Send completed form to the Government Issuing Contracting Officer for the Contract. PR No. listed in Block E.

A. Contract Line Item No.		B. Exhibit		C. Category ENGINEERING		
D. System/Item 5310-01-129-3376			E. Contract/PR NO.		F. Contractor	
1. Data Item No. 0005		2. Title of Data Item: CERTIFICATION/DATA REPORTS			3. Subtitle: BLOCK 16*	
4. Authority (Data Acquisition Document No.) DI-MISC-80678/T3			5. Contract Reference		6. Requiring Office DSCR	
7. DD 250 Req LT	9. Dist Statement Required	10. Frequency AS REQUIRED	12. Date of First Submission BLOCK 16*	14. Distribution		
8. APP Code A		11. As of Date	13. Date of Subsequent Submission BLOCK 16**	a. Addressee	b. Copies	
					Draft Reg Final Repro	
16. REMARKS PARA 10.1, 10.2.1, 10.2.2, 10.2.4, 10.5 APPLY BLOCK 3: SEPARATE REPORTS SHALL BE PROVIDED FOR THE BELOW LISTED SUBTITLES AND SHALL INCLUDE CERTIFICATIONS THAT ALL VENDORS PERFORMING THESE PROCESSES ARE PRIME (OEM) APPROVED SOURCES. IN THE CASE WHERE OTHER THAN THE OEM'S SPECIFICATIONS ARE TO BE UTILIZED, SEPARATE CERTIFICATIONS ARE REQUIRED. 1. MATERIAL CERTIFICATIONS AND ANALYSIS DOCUMENTATION FOR: a. Verify material composition of 4340 HDN Steel Per AMS 6414. 2. PROCESS CERTIFICATIONS FOR: a. Verification of compliance with heat treatment to 180,000 PSI minimum of UTS C39-43 per MIL-H-6875. 3. INSPECTION CERTIFICATIONS: a. Verification and certification of Magnetic Particle Inspection per SS8805. BLOCK 12: *UPON SUBMITTAL OF FIRST ARTICLE TESTING SAMPLE (S) CONTRACTOR SITE: FOR REVIEW GOVERNMENT SITE: AS DELIVERABLE **UPON SUBMITTAL OF PRODUCTION LOT INSPECTION SAMPLE (S) CONTRACTOR SITE: FOR REVIEW GOVERNMENT SITE: AS DELIVERABLE				NAVATR CP	1	
				CODE 3.3.2		
				DCMC/QAR	1	
				DSCP	1	
15. TOTAL				3		

G. PREPARED BY
Timothy L. Bennett

H. DATE
12 May 04

I. APPROVED BY

J. DATE

CONTRACT DATA REQUIREMENTS LIST

Form Approved
OMB No. 0704-0188

The public reporting burden for this collection of information is estimated to average 440 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing the burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. Please DO NOT RETURN your form to the above address. Send completed form to the Government Issuing Contracting Officer for the Contract/PR No. listed in Block E.

A. CONTRACT LINE ITEM NO. B. EXHIBIT C. CATEGORY:
TDP _____ TM _____ OTHER _____

D. SYSTEM/ITEM E. CONTRACT/PR NO. F. CONTRACTOR
5310-01-129-3376

1. DATA ITEM NO. 2. TITLE OF DATA ITEM 3. SUBTITLE
0001 CERTIFICATION DATA REPORTS DETAILED PROCESS/OPERATION SHEETS

4. AUTHORITY (Data Acquisition Document No.) 5. CONTRACT REFERENCE 6. REQUIRING OFFICE
DI-MISC-80678/T1 DEFENSE SUPPLY CENTER P

7. DD 250 REQ 8. DIST STATEMENT REQUIRED 10. FREQUENCY 12. DATE OF FIRST SUBMISSION
LT AS REQUIRED BLOCK 16*
9. APP CODE 11. AS OF DATE 13. DATE OF SUBSEQUENT SUBMISSION
A BLOCK 16*

16. REMARKS
PARA. 10.1. 10.2. 10.2.1. 10.2.2. 10.2.4. 10.5 APPLY//*UPON SUBMISSION OF FIRST ARTICLE TESTING//**IF THE PROCESS/OPERATIONS CHANGES AFTER APPROVAL OF FIRST ARTICLE TEST

14. DISTRIBUTION
a. ADDRESSEE b. COPIES
Draft Final
Reg Repro
NAVAIR CP 3.3.2 1
DSCP 1
CAO 1
15. TOTAL 3

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

1. DATA ITEM NO. 2. TITLE OF DATA ITEM 3. SUBTITLE
0002 CERTIFICATION DATA/ REPORT COMPLETE INSPECTION METHOD SHTS

4. AUTHORITY (Data Acquisition Document No.) 5. CONTRACT REFERENCE 6. REQUIRING OFFICE
DI-MISC-80678/T2 DEFENSE SUPPLY CENTER P

7. DD 250 REQ 8. DIST STATEMENT REQUIRED 10. FREQUENCY 12. DATE OF FIRST SUBMISSION
LT AS REQUIRED BLOCK 16*
9. APP CODE 11. AS OF DATE 13. DATE OF SUBSEQUENT SUBMISSION
A BLOCK 16*

16. REMARKS
PARA. 10.1. 10.2. 10.2.1. 10.2.2. 10.2.4. 10.5 APPLY//*UPON SUBMISSION OF FIRST ARTICLE TESTING//**IF THE PROCESS/OPERATIONS CHANGES AFTER APPROVAL OF FIRST ARTICLE TEST

14. DISTRIBUTION
a. ADDRESSEE b. COPIES
Draft Final
Reg Repro
NAVAIR CP 3.3.2 1
DSCP 1
CAO 1
15. TOTAL 3

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

1. DATA ITEM NO. 2. TITLE OF DATA ITEM 3. SUBTITLE
0003 REQUEST FOR WAIVER/DEVIATION

4. AUTHORITY (Data Acquisition Document No.) 5. CONTRACT REFERENCE 6. REQUIRING OFFICE
DI-NDTI-80640C DEFENSE SUPPLY CENTER P

7. DD 250 REQ 8. DIST STATEMENT REQUIRED 10. FREQUENCY 12. DATE OF FIRST SUBMISSION
LT AS REQUIRED BLOCK 16*
9. APP CODE 11. AS OF DATE 13. DATE OF SUBSEQUENT SUBMISSION

16. REMARKS
ORIGINAL AND TWO COPIES

14. DISTRIBUTION
a. ADDRESSEE b. COPIES
Draft Final
Reg Repro
CAO 1
NAVAIR CP 3.3.2 1
DSCP 1
15. TOTAL 3

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

1. DATA ITEM NO. 2. TITLE OF DATA ITEM 3. SUBTITLE

4. AUTHORITY (Data Acquisition Document No.) 5. CONTRACT REFERENCE 6. REQUIRING OFFICE

7. DD 250 REQ 8. DIST STATEMENT REQUIRED 10. FREQUENCY 12. DATE OF FIRST SUBMISSION
11. AS OF DATE 13. DATE OF SUBSEQUENT SUBMISSION
9. APP CODE

16. REMARKS

14. DISTRIBUTION
a. ADDRESSEE b. COPIES
Draft Final
Reg Repro
15. TOTAL

17. PRICE GROUP

18. ESTIMATED TOTAL PRICE

G. PREPARED BY H. DATE I. APPROVED BY J. DATE
Timothy L. Bennett 12 May 04 William Hord 6/24/04